

Date: Thursday, 9/14/2006 7:27:47 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET		
Job Number	: 28550		Part Number	: D23623		
Estimate Number	: 10260		Drawing Number	: D2362 REV E1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/14/2006		Type	: MACHINED PARTS		
Prsht Rev.	: NC		Drawing Revision	: E1		
First Issue	: N/A		Material	: N/A		
Previous Run	: 27765		Due Date	: 9/30/2006		
Written By	:		Qty:	6	Um:	Each
Checked & Approved By	:		Signature: 06/09/14			
Comment	: Est: G 00.0518		Added inspection level 8 EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2265	Step Support Casting  <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Step Support Pick: Qty Part Number Description Batch 1 D2265 Step Support B25401 J.G 06/09/29 6
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  <b>Comment:</b> Machine per folio D2362-3 J.G 06/09/29 6
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <b>Comment:</b> Inspect Level 2 SA 06.09.29 6
4.0	QC8	SECOND CHECK  <b>Comment:</b> SECOND CHECK SA 06.09.29 6
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr J.G 06/09/29 6
6.0	POWDER COATING	POWDER COATING  <b>Comment:</b> POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3 G.M 06/10/11 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/10/18  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:27:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 28550

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF. 06/10/11

8.0 D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty	Part number	Description	Batch
1	D2397-1	Rubber	627768

9.0 D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty	Part number	Description	Batch
1	D2397-3	Rubber	627769

MF. 06/10/11

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch ~~MF. 06/10/11~~ m100374 MF. 06/10/12

⑥

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/10/16

⑥

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 57773

BB 06/10/17

⑥

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

⑥

Job Completion



1 06/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28550
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362	Rev: E1	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <u>J.G</u>	Audited by: <u>SD</u>	Prototype Approval:	N/A
Date: 06/09/29	Date: 06/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF <i>✓</i>	<i>IT</i>

EI

03.10.07

TOLERANCE

CHANGE

#REF

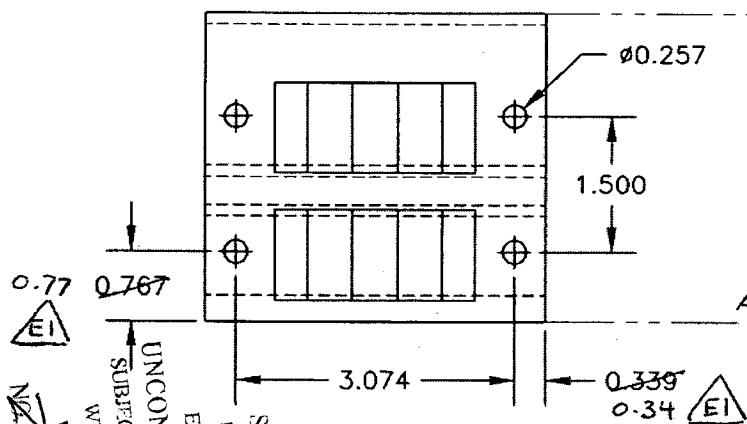
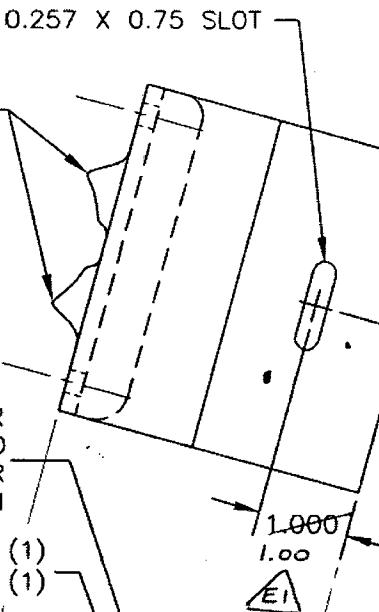
VIEW A-A

0.80  
EI  
0.800  
1.000

REMOVE TIPS  
FROM CASTING  
MAX 0.080

CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)



D2362-3

NOTES:  
MAKER FROM D2265  
UNCONTROLLED SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORIGIN  
RETURN TO  
ENGINEERING  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
98.12.14  
KE



UNDER REVIEW  
QSI 03.15 CP

DESIGN OK, BUT CHECK WITH  
MANUFACTURE  
BEFORE MANUFACTURE

OK if 05/11/97

DESIGN B/W	DRAWN BY GJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2362	SCALE 1:2
DATE 98.12.04	STEP SUPPORT BRACKET	TITLE STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

VIEW A-A



DESIGN	DRAWN BY	
BW	DART AEROSPACE LTD	
CHECKED	HAWKESBURY, ONTARIO, CANADA	
APPROVED	REV. E	
DATE	SHEET 2 OF 3	
98.12.04	SCALE	
	1:2	
	TITLE	
	STEP SUPPORT BRACKET	
	DRAWING NO.	
	D02362	

MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

1.500 1.50

1.87

— Ø0.257

1.500

0.37

R16.680

0.100

BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

0.77 0.767  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK DEPIE  
NOTE  
N 28350

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RELEASE  
UNDER REVIEW  
12-14-94

5  
JES BEFÆRSMANUFAKTUR  
COPENHAGEN, BUTCHER ECK 162  
OK Sept. 1895

~~WILHELM ECK WE  
MANUFACTURER~~  
OK *Phot. Eng.*

D2362-041 (SHOWN)

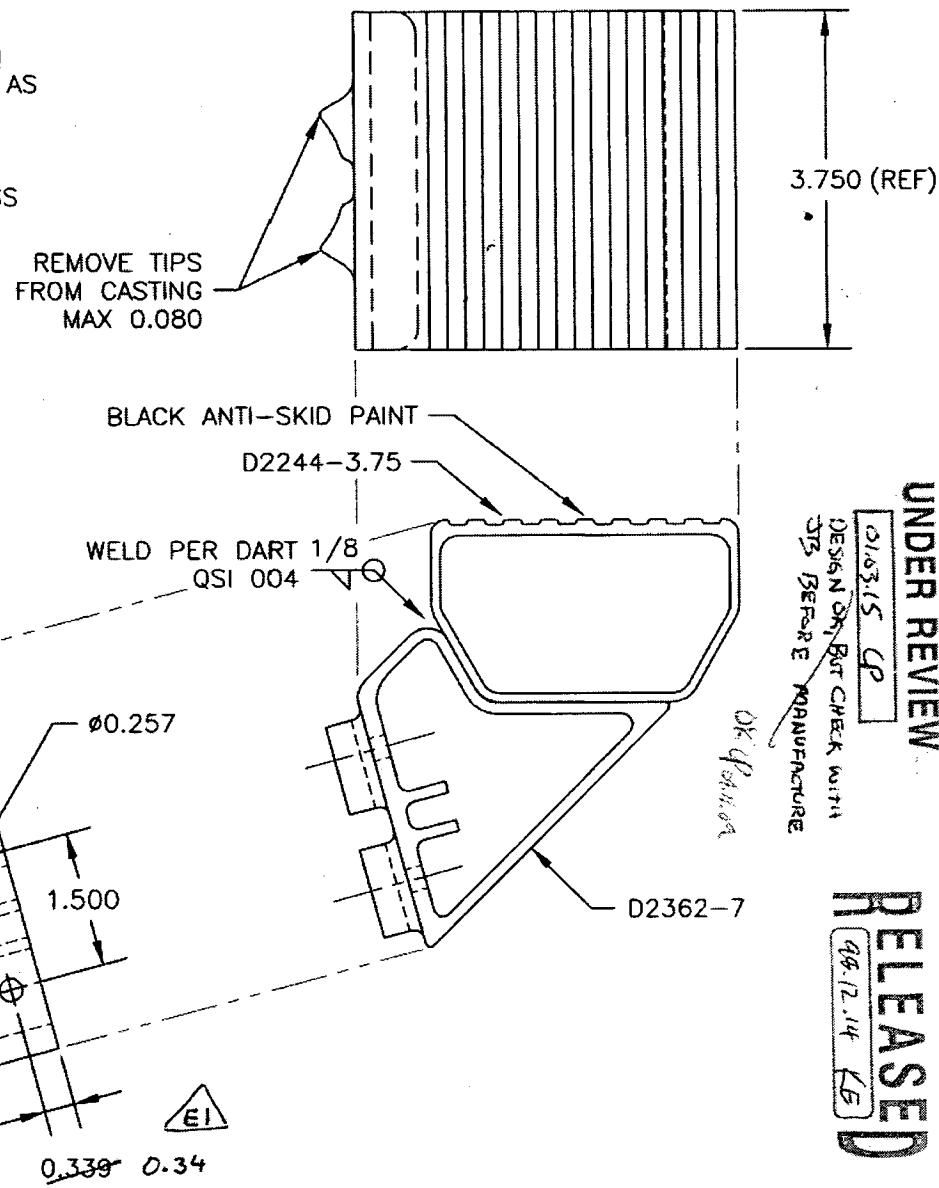
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PLANT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



**DART**

*copy*  
03/03/98

DESIGN BW	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>M</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW

RELEASED  
*98/12/14  
KE*

01/03/95 GP  
DESIGN OK, BUT CHECK WITH  
JB BEFORE MANUFACTURE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28550

